












Date: Tuesday, 26/05/2009 12:47:46 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL LIGHT FAIRING
Job Number	: 48140		
Estimate Number	: 12364		
P.O. Number	:	Part Number	: D3484041
This Issue	: 26/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3484 REV F
First Issue	: / /	Project Number	: N/A
Previous Run	: 48140	Drawing Revision	: F
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 29/05/2009
Checked & Approved By	: <u>JUD 09/05/26</u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-04-11 JLM Est Rev:B 08-01-24 change rivet to CR1122-3-025 DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
			
Comment: Issue P/O: <u>8863</u> <u>C209/05/27</u> (10) Make as per Dwg D3484 Material release note is required			
2.0	D3484041P	Tail Light Fairing Assembly, LH	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Tail Light Fairing Assembly, LH			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached			
4.0	QC9	VISUAL WELDING INSPECTION	
			
Comment: VISUAL WELDING INSPECTION <u>PD 09-06-17</u> (85)			
5.0	QC6	DIMENSIONAL CHECK	
			
Comment: DIMENSIONAL CHECK <u>S09/06/18</u> (41)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3484-041 PAR #: N/A Fault Category: LGE FAB NCR: Yes No DQA: ll Date: 09.07.07
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: / Date: 09.07.15

NCR: <u>48140</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/17	40	two tail light Fairing Fairs with welding touch up. From DART welding inspector (Pat D.)	<u>ll</u> 09/06/17	Fix touch ups as per AST 004 AIR <u>109213</u> Qty <u>42</u>	<u>ll</u> 09/06/17	<u>S</u> 09/06/17	<u>ll</u> 09/06/17	<u>S</u> 09/06/17

NOTE: Date & initial all entries

Date: Tuesday, 26/05/2009 12:47:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 48140

Part Number: D3484041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(X10)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ump 09/06/22

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-22

8.0 CR1122 3 025 RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

Batch:

M110849

M-H 09/06/23

9.0 MS2106904 ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

ANCHOR NUT

Batch:

M110916

M-H 09/06/23

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



(10X)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

M-H 09/06/23

11.0 QC5 INSPECT WORK TO CURRENT STEP



(-041)

Comment: INSPECT WORK TO CURRENT STEP

S 02/06/23

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

2:30pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

3:00pm

91 09-06-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 26/05/2009 12:47:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 48140

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09.06.23 (10)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-141 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

57203

09/06/24 (10)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/24 (10)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion



U 09.06.24

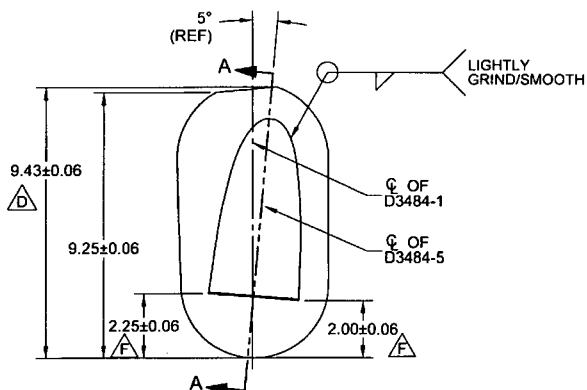
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

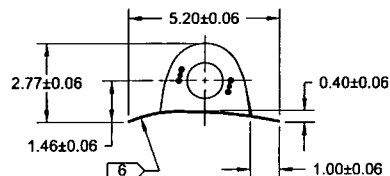
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

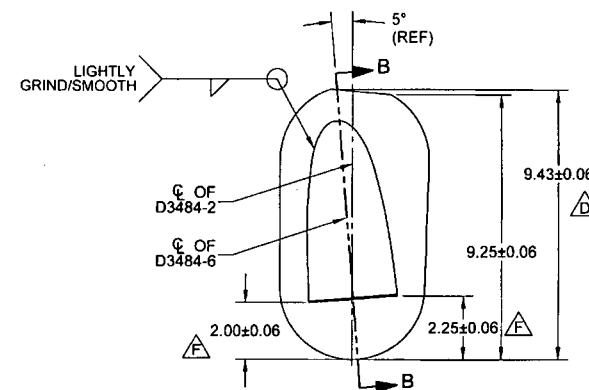


QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
		D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
1	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
1	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
1	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT

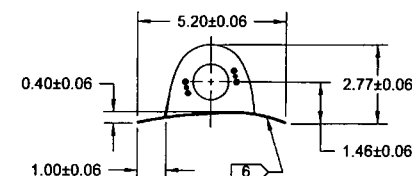


SECTION A-A

D3484-041 TAIL LIGHT FAIRING

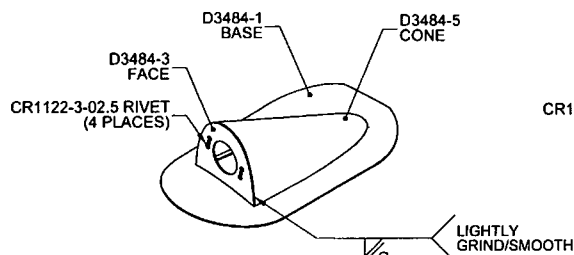


INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

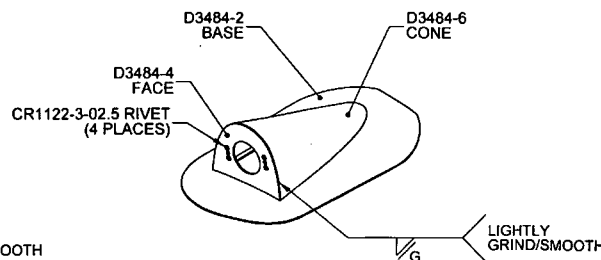


SECTION B-B

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) WELDING: PER DART QSI 004
 - 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
 - 7) WEIGHT: 0.30 lbs

RELEASED
9/27/97

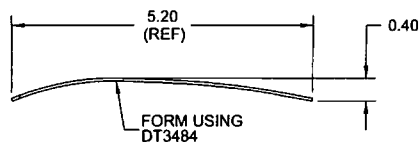
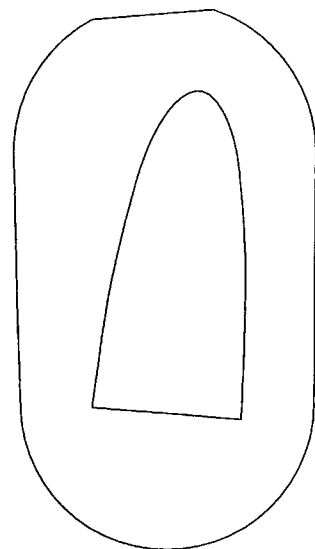
F	UPDATE MATERIAL SPEC. ADD 6061-0, ZN A7-2, A7-3, B3-4. UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1. UPDATE WELDING NOTE ZN A3-1, A6-1	MB	09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.50 WAS 1.583 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.31		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

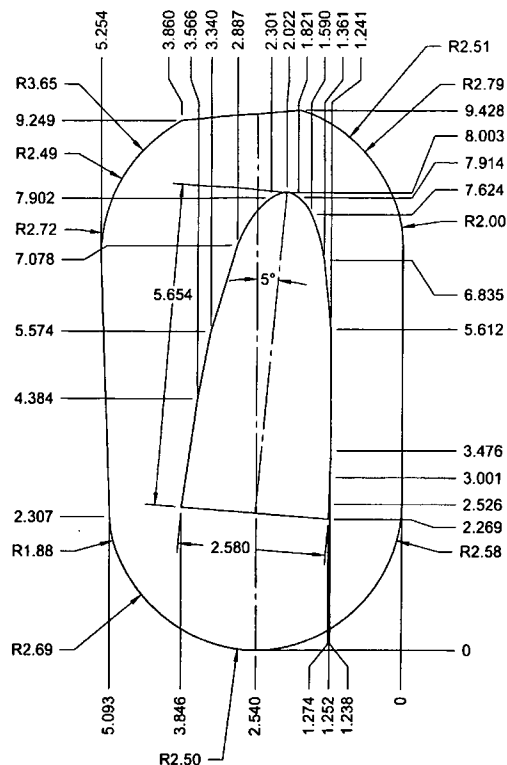
DRAWING NO. D3484
SHEET 1 OF 4
TITLE TAIL LIGHT FAIRING
SCALE 1:4

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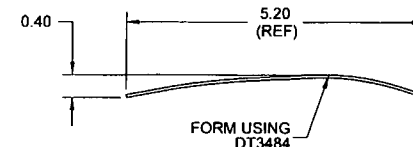
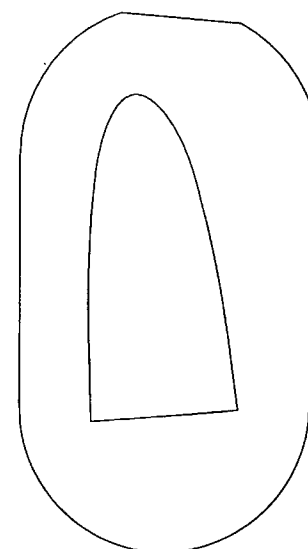
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D3484-1 BASE
(MAKE FROM D3484-1F)









D3484-1F BASE FLAT PATTERN



D3484-2 BASE
(MAKE FROM D3484-1F)

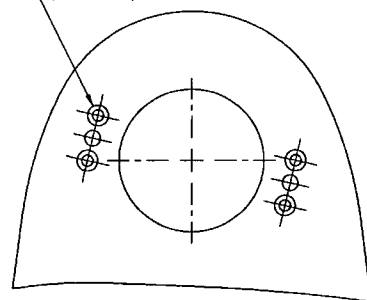
RELEASED
09/10/24/10

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

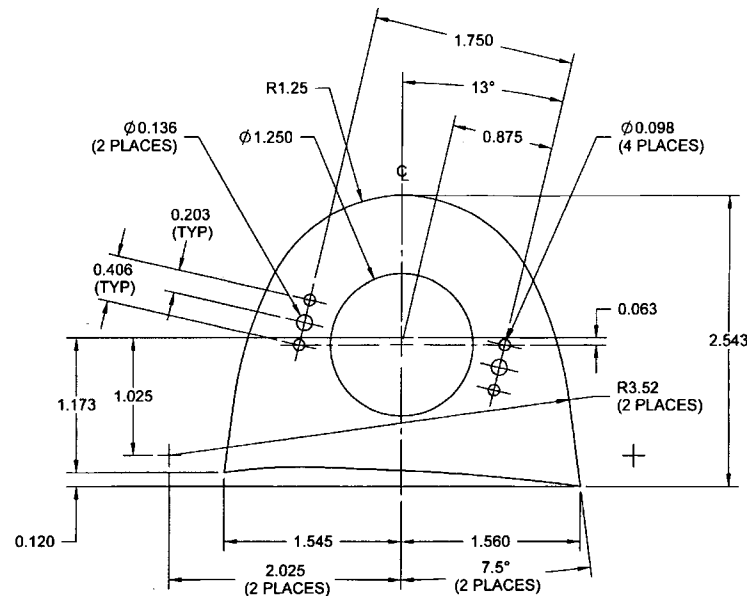
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
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NO. 49140
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C'SINK
Ø 0.181 X 100°
(4 PLACES)

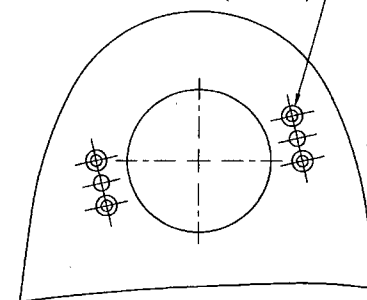


D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

C'SINK
Ø 0.181 X 100°
(4 PLACES)



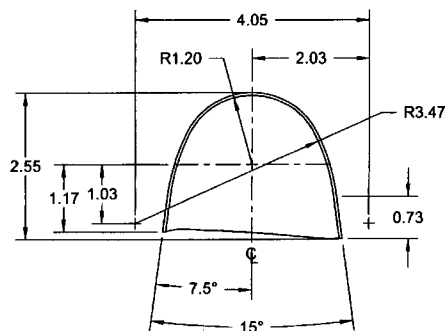
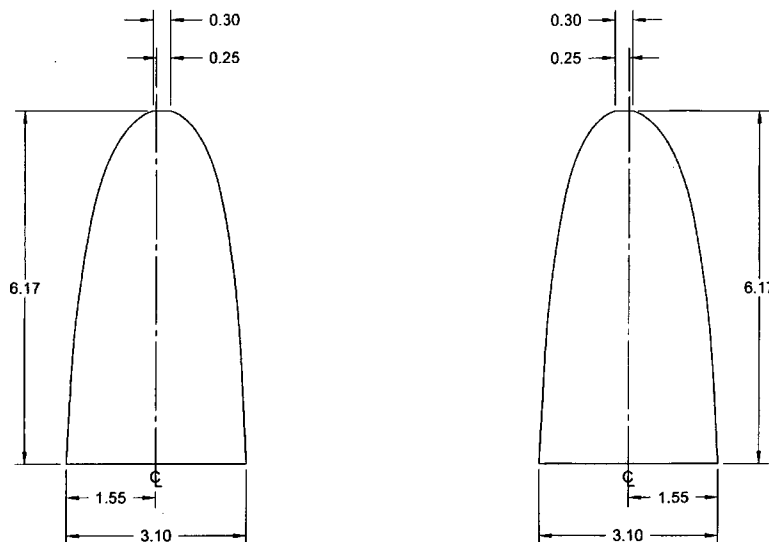
D3484-4 FACE
(MAKE FROM D3484-3F)

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

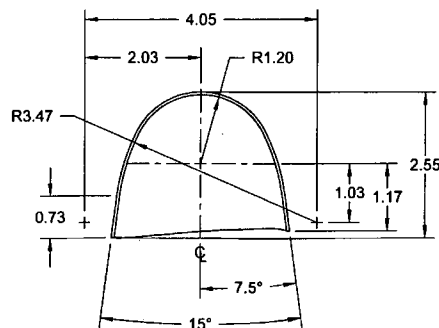
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09/07/24

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 3 OF 4
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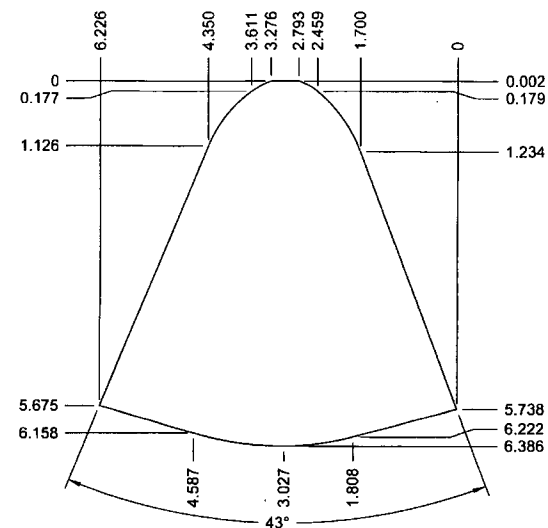
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D3484-5 CONE
(MAKE FROM D3484-5F)









D3484-6 CONE
(MAKE FROM D3484-5F)



D3484-5F CONE FLAT PATTERN

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

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180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VI NDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2009/06/11	0420166

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	J0201213	PO00008863	
QUANTITE QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
10	D3484041P <i>Sorlockis</i>	TAIL LIGHT FAIRING CERTIFICATE OF CONFORMANCE REQ	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

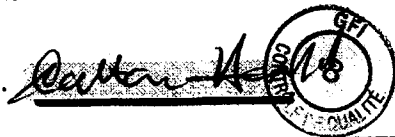
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>1</u>		OUR JOB NO. <u>J0201213</u>		SHIPPING MEMO <u>0420166</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>--</u>	<u>10 PCS</u>	<u>PO00008863</u>	<u>D3484041P</u>	<u>F</u>	<u>TAIL LIGHT FAIRING</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>AL 6061-T0</u>		<u>SAMUEL / ALCOA INC</u>		<u>564405</u>	
PROCESS			PROCESSOR		RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>		<u>GFI</u>		<u>CONFORMS</u>
2					
3					
4					
5					
6					
7					
8					
9					

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 11 JUNE 2009

G.F.I. Q.C. REP.



**LES MÉTAUX
SPÉCIALISÉS**
SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: FEBRUARY 9, 2009

Company Name: GFI Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe-Claire Qc
Zip Code: H9R 1A1

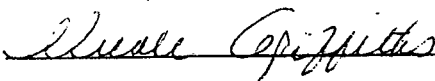
du client: 0075178 **# de commande SSMQ:** 327150
Customer's order #: **SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	1	.050" X 48" X 144"	6061-0	AMS 4025	564405

Bien à vous,
Yours truly,



Commis à l'administration.
Administration Clerk.



80966118

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

924669 0
Ship Date B.L. No. Invoice No. Alcoa No. Item
2008-05-30 2963186 00000 5043842-2
P.O. No./Govt Contract No. Customer Mfg Order
N20720 SAMUEL SON & CO LT DCE-43842-2

Page 1

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
0.05 IN TK (+0.0000 - .0035) X 48.0 IN W (+.125 - .125) X 144.0 IN LN (+.15625 - .15625) (N) A/T 6061-O FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-250/11 EXC MRK AMS4025 REV K EXC MRK ASTMB209 REV 07 EXC MRK CMMPO25 REV Q EXC MRK CMMPO19 REV D EXC MRK CSTI008 REV D ((MARKED)) KRAFT PAPER INTERLEAVED
MAX GROSS SKID WGT: 6000 LB QUAN TOL +0
-30 % CQR 0216075 REV 01 CUST REQ 08-03-01 *** W/E 08-04-05 ***

um	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
--	623928	564405	4317	132	PC	:

otes for CQR: 0216075.1

RODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ- A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PROD UCT
RODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.
xception to Spec CMMPO25 ; Revsn: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B. .
xception to Spec CMMPO19 ; Revsn: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL .
xception to Spec CSTI008 ; Revsn: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL .

CQR: 0216075.1 -Specification Limits

	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
'mpr	Long Transv.	22.0	12.0			16
'mpr	Long Transv.	30.0	14.0			16
'mpr	Long Transv.	42.0	35.0			10

